

Work Order ID 50019



Page 1

July 6, 2009 7:38:23 AM

Item ID: D212-664-101

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 08/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 24/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D212-664-141	Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-664-101 CHG003

S 09/07/24

HJ 09/07/23

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

P 9/1/16 (1)

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

MB

09-07-13

(1x)

Work Order ID 50019

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Page 2

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Accept



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Start Date: 08/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 24/07/2009 Req'd Qty: 1.00



Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

27 5 09/07/13 (1)

140

Crosstubes

0.00



Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549 1/2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment wi

MB 09-07-14 (14) AUM 8-7-14

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Chemical Conversion Coat within 24 hours of bending and drilling

-AUM 8-7-14

Work Order ID 50019

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Page 4

Item ID: D212-664-101

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Start Date: 08/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 24/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect for damage & ensure results are as per Dwg D212-664-141

4T 07-07-20

200



SprayPaint

Spray Painting

SprayPaint

0.00

Memo

0.00

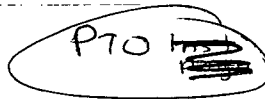
1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2

☐ PRIME: ☐ Start

Time: 10:30 ☐ Finish Time: 11:30 ☐ PAINT: ☐ Start

Time: 3:30 ☐ Finish Time: 4:30

ml 09 07 20 ①



210



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

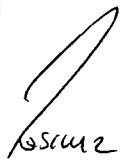


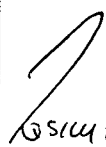
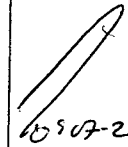
0.00

Then, Wrap in plastic bag to protect from scratches

4T 09-07-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-101 PAR #: PLA Fault Category: Cross tube NCR: Yes No DQA: 1 Date: 09.07.27
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: 1 Date: 09.08.19

NCR: <u>50019</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.07.21	200	Paint was a little thin on top of tube, tubes are hung upside down. re-process.		Sand & re-paint per QS1005 m 111629 Imron white.	 09.07.21	 09.07.27		 09.07.21

NOTE: Date & initial all entries

Work Order ID 50019

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Page 5

Item ID: D212-664-101

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 08/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 24/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe 12-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs 1A/R 6398 Magnobond Batch: 111249 exp' 01/2010

Torque: ml 09 07 23 ①

230

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

⇒ S 07/12/23

④

240

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

09/17/23 ④

Work Order ID 50019

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Item ID: D212-664-101

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 08/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 24/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

⇒ 8/07/24

40

φ

260

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212-664-101

Rev E

9/7/24 1054

270

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/27

W 09.07.27

Picklist Print

July 6, 2009 7:38:22 AM

Work Order ID: 50019

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd

Comments:

Start Date: 08/07/2009

Required Date: 24/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L6

Purchased

No

100

Each

803.0000

6.0000 6



Nut

9/7/23 EV

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

803

105077

22

110002

275

111548

100

111578

400

19099

6

11/0002 6x

D212-664-

101TRNRevC

Manufactured

No

220

Each

2.0000

1.0000



Crosstube Turning Detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

48316

1

48317

1

✓ 1x MB 09-07-13 (1x)

Picklist Print

July 6, 2009 7:38:23 AM

Work Order ID: 50019

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd


Comments:

Start Date: 08/07/2009

Required Date: 24/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2893-1RevB		Manufactured	No			220	Each	78.0000	2.0000			
												
2.75 Support												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	78	
25657	6	
43479	16	
46488	18	
47109	18	
47637	20	

MM 09.07.22

D3595-063-450RevA

Manufactured

No

220

Each

63.8000

4.2105



RUBBER CUSHION

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	63.8	
38959	2	
43210	12.8	
46465	49	

MM 09.07.22

Picklist Print

July 6, 2009 7:38:23 AM

Work Order ID: 50019

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd




Comments:

Start Date: 08/07/2009



Required Date: 24/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S AN6-35A  BOLT		Purchased	No			250	Each	42.0000	4.0000 		9/7/23 	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	42	
111605	42	

S AN6-36A  Bolt		Purchased	No			250	Each	77.0000	4.0000 			
--	--	-----------	----	--	--	-----	------	---------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	77	
109632	1	
110382	26	
111650	50	

M111605 42
PC 9/7/23

M110382 26

Picklist Print

July 6, 2009 7:38:23 AM

Page 4

Work Order ID: 50019

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd



Comments:

Start Date: 08/07/2009



Required Date: 24/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S AN960JD616  Washer		Purchased	No			250	Each	484.0000	18.0000 		9/7/23	CU

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	484	
107242	3	
107959	6	
109371	8	
110704	23	
111193	18	
111607	426	

S D3428-1RevA  Placard		Manufactured	No			250	Each	18.0000	1.0000 		9/7/23	CU
---	--	--------------	----	--	--	-----	------	---------	---	--	--------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
47310	8	
48359	10	

July 6, 2009 7:38:23 AM

Shop Packet Print

Page 4

Picklist Print

July 6, 2009 7:38:23 AM

Work Order ID: 50019

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd


Comments:

Start Date: 08/07/2009

Required Date: 24/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25		Purchased	No			250	Each	164.0000	4.0000			
												
Clamp(per MIL-DTL-8783C)												

Warehouse Loc Qty Loc Code

Location

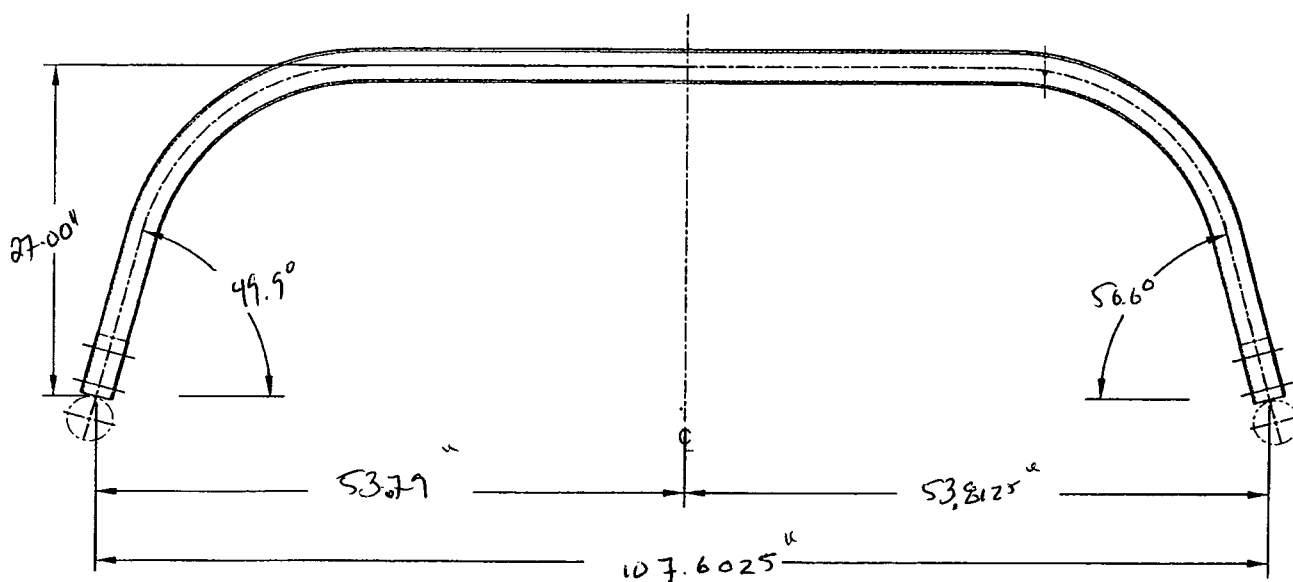
Main Warehouse

ST	164	
107456	2	
108111	3	
108975	17	
109181	48	
109644	10	
111282	50	
111429	25	
111883	9	

mm 09-07-22

DART AEROSPACE LTD		Work Order:	50019
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	S
Date	09/07/13

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	

DART**RELEASED**

07.04.24

DEO ATTACHED

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED GP	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

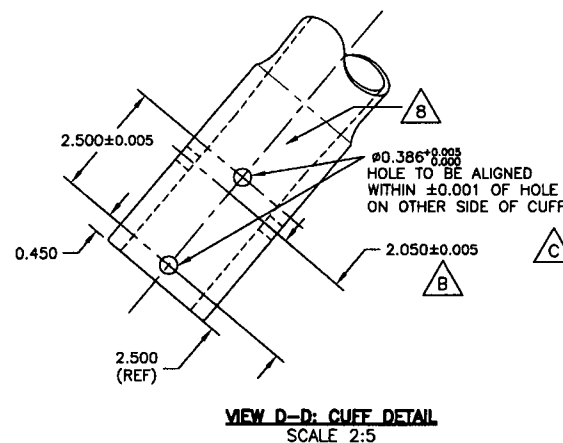
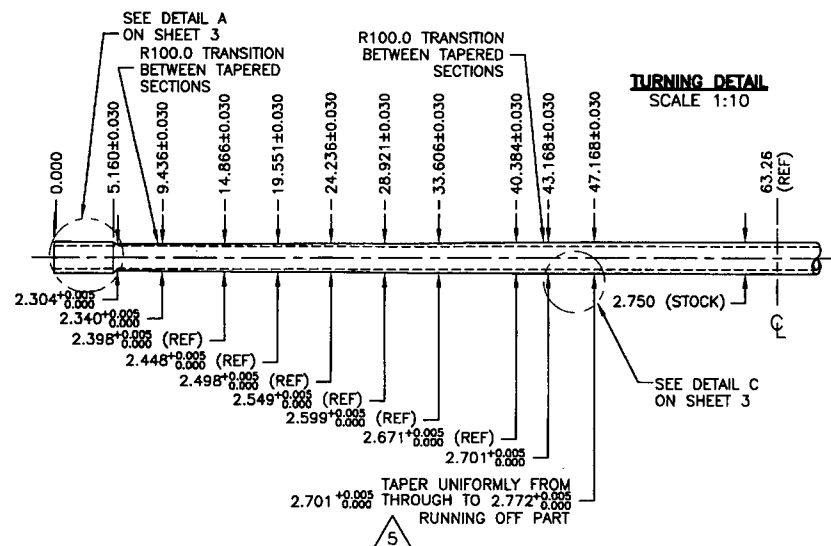
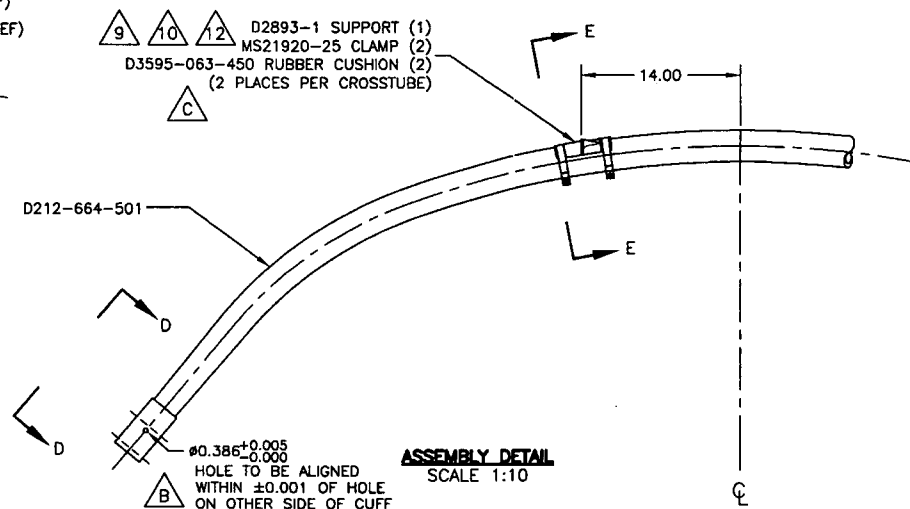
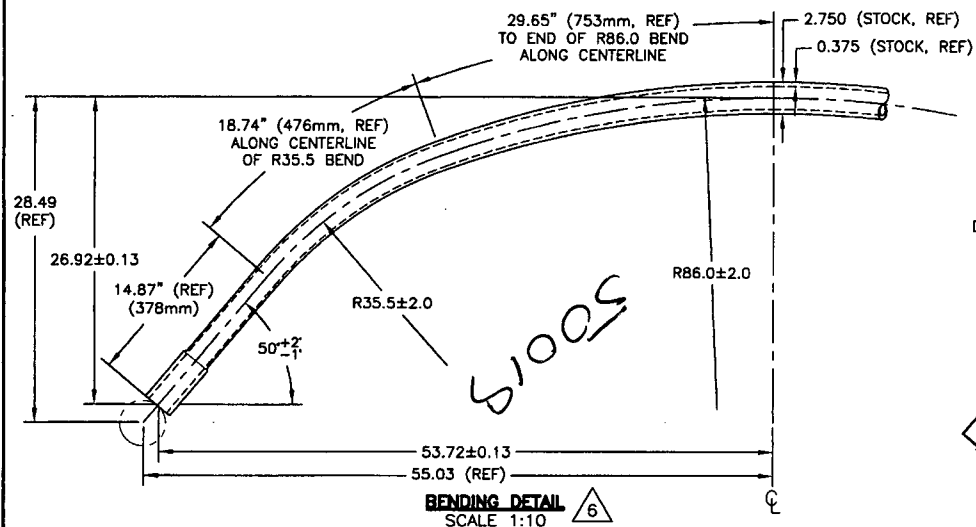
Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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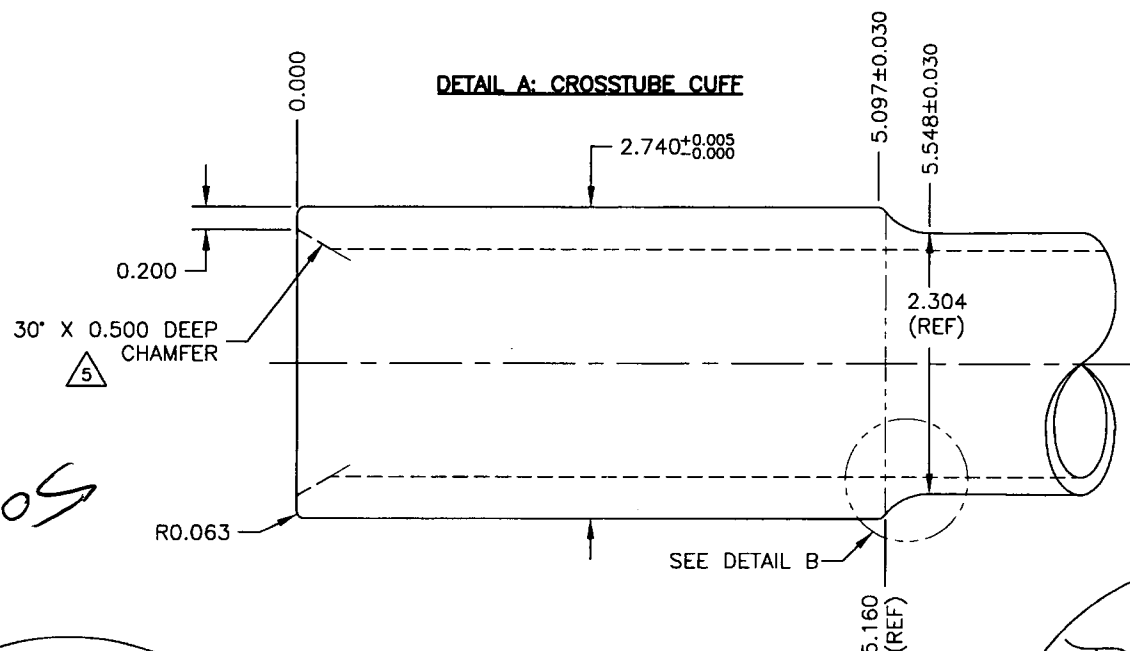
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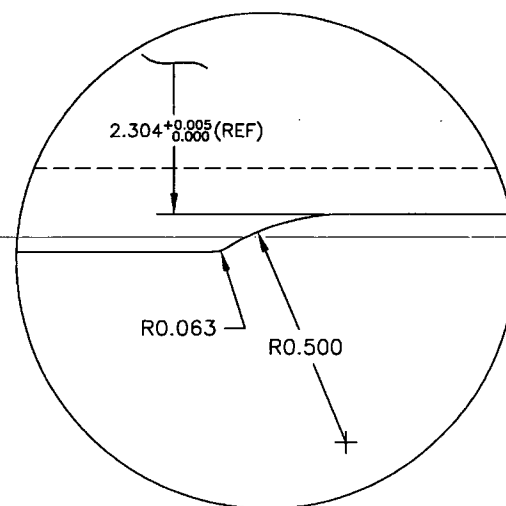
RELEASED
67.04.24 (P)
PER GEN 897

DEO ATTACHED

DETAIL A: CROSSTUBE CUFF

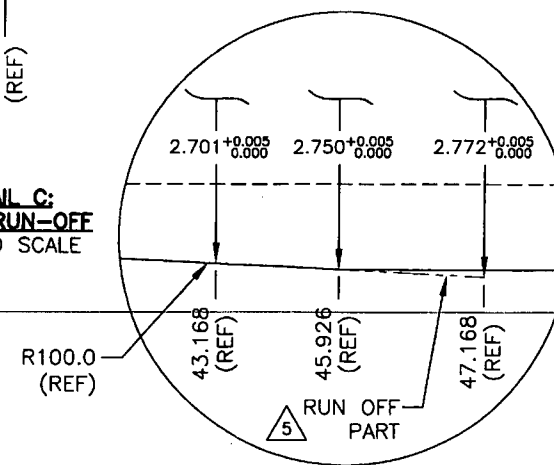


b'005



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DART AEROSPACE LTD.

DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED J	APPROVED J	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE 07.03.08	TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:1	

DRAWING NO. D212-664-141	TITLE CROSSTUBE	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>(1)</i>	CHECKED <i>RE</i>	MFG. APPR. <i>RE</i>	APPROVED <i>MD</i>	DE APPR. <i>TH</i>		
DATE 09.05.01	DATE 09.06.15	DATE 09.06.15	DATE 09/06/16	DATE 09/06/16		

CHANGE:

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)

THE D212-664-141B CROSSTUBE HAS THE SAME PARTS LIST AS THE D212-664-141 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D212-664-141 CROSSTUBE.

RELEASED
09/06/22 *MD*

61005

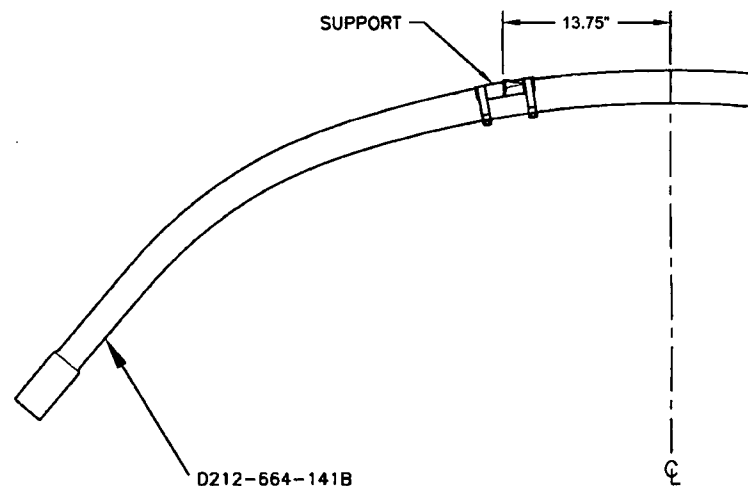


FIGURE 1 - SUPPORT INSTALLATION



LIQUID PENETRANT TEST REPORT

P- 14943

CLIENT	DART AEROSPACE	DATE	July 16-2009	PAGE	1	OF	1		
ATTENTION	LINDA/CHWTEL	ACUREN JOB NO.	188-09-001468	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST. HAWKES BURY, ON. K6H 1K7	PO/WO NO.		WORK LOCATION	HAWKES BURY	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2007
PROJECT	F.P.I. ON CROSS TUBES								
ITEM(S) EXAMINED	6 - X - TUBES								

JOB DESCRIPTION	PROCEDURE NO. LT-XXX REV./DATE	TECHNIQUE NO. LT-XXX-XXX REV./DATE
PART NO.	MATERIAL	THICKNESS
SCOPE	WET FLOUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL	

TEST DETAILS	
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE
FAMILY BRAND	MAGNA FLUX
PENETRANT	ZL 67
PENETRANT REMOVER	H2O
DEVELOPER	SKD 52
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY
MINIMUM DWELL TIME	45 MIN.
MINIMUM DRY TIME	>10 MIN.
MINIMUM DWELL TIME	10 MIN.
WATER WASH	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
BLACK LIGHT S/N	16459
FLASHLIGHT	<input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT
OUTPUT	>1000 μ W/cm ²
OUTPUT	>100 fc @ SURFACE
OTHER	LAB NO
LIGHT METER S/N	
CAL DUE DATE	DEC. 8-2009

TEST SURFACE	
SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F <input checked="" type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F <input type="checkbox"/> > 52°C/ 125°F

RESULTS-	(<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)
Work order #	
1 - 50081	✓
1 - 50094	✓
1 - 50045	✓
1 - 50019	✓
1 - 50038	✓
1 - 50044	✓
No RELEVANT INDICATIONS WERE FOUND ON THESE SIX CROSS TUBES	

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	DTR # E-27929
TECHNICIAN (SIGNATURE):	REPORT REVIEWED BY:
NAME (PRINT):	NAME INITIALS
CGSB LEVEL	CGSB LEVEL
CGSB REG. NO.	CGSB REG. NO.